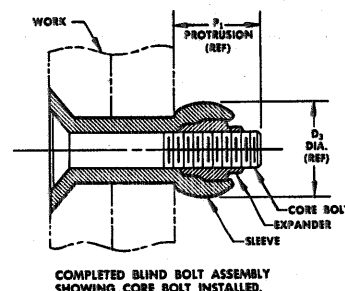
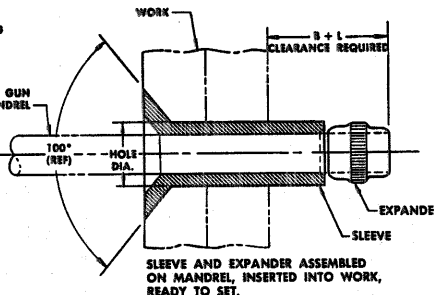
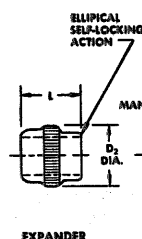
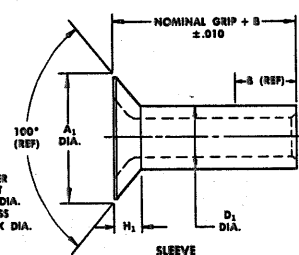
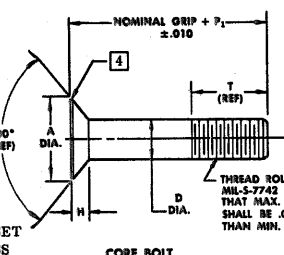
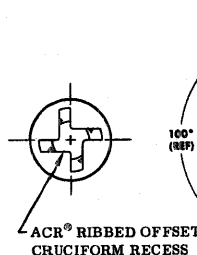


hi-shear
CORPORATION

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TORRANCE, CALIFORNIA 90509
AREA CODE 213 • 775-3181 • 326-8110



BLIND BOLT ASSEMBLY			BB703 CORE BOLT								BB321 SLEEVE								BB341 EXPANDER				SUGGESTED HOLE PREPARATION		PROTRUSION AFTER INSTALLATION		INSTALLATION PRESSURE (psi) USING HI-SHEAR TOOLING		
FIRST DASH NUMBER	NOMINAL DIAMETER	MIN. GRIP	FIRST DASH NUMBER	RECESS	A DIA.	D DIA.	H	P ₁	T (REF)	THREAD	FIRST DASH NUMBER	A ₁ DIA.	S GRIP RANGE 0-3/8	S GRIP RANGE 1 1/16-1 1/8	S GRIP RANGE 1 1/4-1 3/8	S GRIP RANGE 1 1/2-1 5/8	D ₁ DIA.	H ₁	DASH NUMBER	D ₂ DIA.	L (LENGTH)	THREAD	HOLE DIA.	CORE BOLT INSTALLATION TORQUE	P ₁	P ₂ DIA. (REF)	BG1750	BG2500	
-12	3/8	-4	-12	10	.5066 .5018	.2490 .2470	.108 .106	.485	.567	1/4-28UNJF-3A	-12	.7604 .7556	.450	.450	.450	—	.390 .387	.1554 .1534	-12	.383	.368	1/4-28UNJF-3B	.397 .391	125 150 IN. LBS.	.485	.510	—	1450	

BB703 CORE BOLT

GENERAL NOTES:

1. Concentricity: Head to "D" diameter within .005 FIR.
2. Complete threads shall begin within two thread pitches maximum. Two thread pitch maximum may consist of incomplete thread and extrusion angle.
3. "H" is dimensioned from maximum "D" diameter.
4. Curved or flat edge manufacturer's option.

MATERIAL: A-286 high temperature alloy per AMS 5731 or AMS5737.

HEAT TREAT: 95 KSI shear minimum.

CODE: First dash number of core bolt indicates sleeve nominal diameter in 32nds. Second dash number indicates grip length (thickness of work) in 16ths.

EXAMPLE: BB700-12-10 = 1/4-28 core bolt for 3/8 nominal diameter sleeve, 5/8 grip length.

BB700 BLIND BOLT ASSEMBLY

CODE: First dash number indicates nominal diameter of Blind Bolt Assembly in 32nds.
Second dash number indicates grip length (thickness of work) in 16ths.
Minimum grip in table shows the lowest second dash number available.
Letters "G" or "GU" after basic assembly number indicate silver plated expanders.
Letters "P" or "PB" after basic assembly number indicate type of cadmium plate.

BB321 SLEEVE

GENERAL NOTES:

1. Concentricity: Hole to "D1" diameter within .005 FIR.
2. "H1" is dimensioned from maximum "D1" diameter.

MATERIAL: Type CRES: 305 per QQ-S-763, 302 HQ, or 18-9LW (ASTM A-493).

FINISH: BB321 = Passivate.
BB321P = Cadmium plate per QQ-P-416, Type I, Class 2.
BB321PB = Cadmium plate per QQ-P-416, Type II, Class 2.

CODE: First dash number indicates nominal diameter of sleeve in 32nds. Second dash number indicates grip length (thickness of work) in 16ths. Letters "P" or "PB" indicate type of plating.

EXAMPLE: BB321-12-10 = 3/8 nominal diameter sleeve, 5/8 grip length.

EXAMPLE: BB700-12-10
— 5/8 Grip Length
— 3/8 Nominal Diameter Blind Bolt Assembly
Blind Bolt Assembly which includes: BB703 Core Bolt, BB321 Sleeve, and BB341 Expander

BB700G-12-10 = As example except with Expander BB341G.
BB700GU-12-10 = As example except with Expander BB341GU.
BB700P-12-10 = As example except with Sleeve BB321P.
BB700PB-12-10 = BB703 Core Bolt, BB321PB Sleeve and BB341PB Expander

BB341 EXPANDER

GENERAL NOTES:

MATERIAL: Type AISI 431 stainless steel.

HEAT TREAT: 125,000 psi shear minimum.

FINISH: BB341 = Cadmium plate per QQ-P-416, Type I, Class 2, and cetyl alcohol lube.
BB341DU = Solid film lubricant per MIL-L-8937.
BB341G = Silver plate per AMS 2410 and cetyl alcohol lube per Hi-Shear Spec. 305.
BB341GU = Silver plate per AMS 2410 (dry) no lube.
BB341PB = Cadmium plate per QQ-P-416, Type II, Class 2, and cetyl alcohol lube.

CODE: Dash number indicates diameter of Blind Bolt Assembly in 32nds. Letters "G", "GU" or "PB" indicate type of plating. Letters "DU" indicate solid film lube.

EXAMPLE: BB341-12 = 1/4-28 Expander for use with 3/8 nominal diameter Blind Bolt Assembly.

"Blind Bolt" is a trademark of Hi-Shear Corporation.
"ACR" is a trademark of Phillips Screw Company.

TITLE					
BLIND BOLT™ ASSEMBLY					
100° COUNTERSUNK AN509 HEAD STYLE					
Sheet 1 of 2					
DRAWN	DATE	APPROVED	DATE	REVISION	DATE
D.P.S.	11-25-86				
DRAWING NUMBER					BB700

GRIP TABLE

SECOND DASH NO.	GRIP	GRIP RANGE
1	-	-
2	-	-
3	-	-
4	1/4	.250 .187
5	5/16	.312 .250
6	3/8	.375 .312
7	7/16	.437 .375
8	1/2	.500 .437
9	9/16	.562 .500
10	5/8	.625 .562
11	11/16	.687 .625
12	3/4	.750 .687
13	13/16	.812 .750
14	7/8	.875 .812
15	15/16	.937 .875
16	1"	1.000 .937
17	1-1/16	1.062 1.000
18	1-1/8	1.125 1.062
19	1-3/16	1.187 1.125
20	1-1/4	1.250 1.187

SECOND DASH NO.	GRIP	GRIP RANGE
21	1-5/16	1.312 1.250
22	1-3/8	1.375 1.312
23	1-7/16	1.437 1.375
24	1-1/2	1.500 1.437
25	1-9/16	1.562 1.500
26	1-5/8	1.625 1.562
27	1-11/16	1.687 1.625
28	1-3/4	1.750 1.687
29	1-13/16	1.812 1.750
30	1-3/4	1.875 1.812
31	1-15/16	1.937 1.875
32	2"	2.000 1.937
33	2-1/16	2.062 2.000
34	2-1/8	2.125 2.062
35	2-3/16	2.187 2.125
36	2-1/4	2.250 2.187
37	2-5/16	2.312 2.250
38	2-3/8	2.375 2.312
39	2-7/16	2.437 2.375
40	2-1/2	2.500 2.437

SECOND DASH NO.	GRIP	GRIP RANGE
41	2-9/16	2.562 2.500
42	2-5/8	2.625 2.562
43	2-11/16	2.687 2.625
44	2-3/4	2.750 2.687
45	2-13/16	2.812 2.750
46	2-7/8	2.875 2.812
47	2-15/16	2.937 2.875
48	3"	3.000 2.937
49	3-1/16	3.062 3.000
50	3-1/8	3.125 3.062
51	3-3/16	3.187 3.125
52	3-1/4	3.250 3.187
53	3-5/16	3.312 3.250
54	3-3/8	3.375 3.312
55	3-7/16	3.437 3.375
56	3-1/2	3.500 3.437
57	3-9/16	3.562 3.500
58	3-5/8	3.625 3.562
59	3-11/16	3.687 3.625
60	3-3/4	3.750 3.687

BLIND BOLT™ ASSEMBLY
100° COUNTERSUNK AN509 HEAD STYLE

DRAWING NUMBER
BB700

Sheet 2 of 2